

### Amendments to the Claims

1. (Withdrawn) A method of forming an upper case of a keyboard, said upper case of a keyboard including an opening, said opening defining a rim, said method comprising:

- (a) filling a mold with plastic substance using said opening as an entrance to form a semi-finished upper case;
- (b) releasing said mold to retrieve said semi-finished upper case; and
- (c) affixing a movable housing on said rim of said opening.

2. (Withdrawn) The method of claim 1, further comprising cutting a scrap between said step (b) and said step (c).

3. (Withdrawn) The method of claim 2, wherein a diameter of said opening is substantially not less than 1mm.

4. (Withdrawn) The method of claim 2, wherein in said step (c), said movable housing is affixed on said rim of said opening by one or more screws.

5. (Withdrawn) The method of claim 2, wherein in said step (c), said movable housing is lodged in said rim of said opening.

6. (Withdrawn) The method of claim 2, wherein in said step (c), said movable housing is fused and affixed on said rim of said opening.

7. (Withdrawn) The method of claim 1, further comprising cutting a gate between said step (b) and said step (c).

8. (Currently Amended) An upper case of a keyboard, comprising:  
a panel including an opening and ~~an integrally formed immovable housing~~ a first keyhousing integrally formed with said panel, said opening defining a rim; and a ~~movable housing~~ second keyhousing affixed on said rim of said opening, wherein said ~~movable housing~~ second keyhousing is formed non-integrally with said panel.

9. (Currently Amended) The upper case of a keyboard of ~~claim~~ Claim 8, wherein said ~~movable housing~~ second keyhousing is affixed on said rim of said opening by one or more screws.

10. (Currently Amended) The upper case of a keyboard of ~~claim~~ Claim 8, wherein said ~~movable housing~~ second keyhousing is lodged in said rim of said opening.

11. (Currently Amended) The upper case of a keyboard of ~~claim~~ Claim 8, wherein said ~~movable housing~~ second keyhousing is fused and affixed on said rim of said opening.

12. (New) The upper case of a keyboard of Claim 8, wherein said panel comprises only one said opening.

13. (New) The upper case of a keyboard of Claim 8, wherein said panel comprises only one second keyhousing.

14. (New) The upper case of a keyboard of Claim 8, wherein a diameter of said opening is more than 1mm.

15. (New) An upper case of a keyboard, comprising:

- a panel having an opening and a plurality of first key housings integrally formed with said panel, said opening defining a rim; and
- a second keyhousing positioned above said opening, said second keyhousing being formed non-integrally with said panel;

wherein said plurality of first key housings are integrally formed with said panel by flowing a melt plastic into a mold through said opening.

16. (New) The upper case of a keyboard of Claim 15, wherein said panel comprises only one said second keyhousing.

17. (New) The upper case of a keyboard of Claim 15, wherein said panel is formed without any welding line created by meeting said melt plastic.

18. (New) The upper case of a keyboard of Claim 15, where said panel comprises only one said opening.

19. (New) The upper case of a keyboard of Claim 15, wherein said second keyhousing is affixed on said rim of said opening

20. (New) The upper case of a keyboard of Claim 15, wherein a diameter of said opening is more than 1mm.